

Work Order ID 149736

149736

Wednesday, July 27, 2016 1:47:25 PM

Page 1

Item ID: D206-642-561PHI

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Replacement Skidtube, High Gear, Standard Wearplates, DART (Apical) Tri-Bag Float Compatible

Stop ***NS2***

Start Date: 7/27/2016 Start Qty: 1.00 ***1***

Required Date: 8/1/2016 Req'd Qty: 1.00 ***1***

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: U Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSI 9749									
280	QC5- Inspect part completeness to step on W/O	0.00							
280									
QC									
Quality Control	Memo PULL FROM W/O: 1 X D206-642-541PHI B <u>47159</u> RE-IDENTIFY AS D206-642-561PHI USING NEW B/N PER ECN016-616, DSI9749	0.00							
									DAS 9 9-89
290	Identify as per dwg & Stock Location: _____	0.00							
290									
Packaging									
Packaging	Memo	0.00							

DAS
27
9-89
AUG 04 2016

Work Order ID 149736

149736

Wednesday, July 27, 2016 1:47:25 PM

Page 2

Item ID: D206-642-561PHI

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Replacement Skidtube, High Gear, Standard Wearplates, DART (Apical) Tri-Bag Float Compatible

Start Date: 7/27/2016 Start Qty: 1.00 *1*

Required Date: 8/1/2016 Req'd Qty: 1.00 *1*

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
300	QC21- Final Inspection - Work Order Release	0.00							
300									
QC	Memo	0.02							
Quality Control									

DAS
21
9-89

AUG 03 2016

54 8/3/16

Picklist Print

Wednesday, July 27, 2016 1:47:24 PM

Page 1

Work Order ID: 149736

149736

Parent Item: D206-642-561PHI

D206-642-561PHI

Parent Item Name: Replacement Skidtube,High Gear, Standard Wearplates, DART (Apical) Tri-Bag
Float Compatible

Start Date: 7/27/2016

Required Date: 8/1/2016

Comments: IPP REV REV:A 16.07.19 NEW ISSUE DD VERF:JFS

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D206-642-541PHI		Manufactured	No				Each	0.0000		1			
D206-642-541PHI													
Repl.Skid.,High Gear,Std Wearplates Fits LH/RH, DART Tri-Bag Float Comp.													

Linda Lacelle

From: Marie Lajeunesse
Sent: Wednesday, July 27, 2016 6:51 AM
To: Linda Lacelle
Subject: RE: Re: ECN 16-616, PHI skidtubes

From: Chris Provencal
Sent: Tuesday, July 26, 2016 4:52 PM
To: Kim Johnston <kjohnston@dartaero.com>
Cc: William Monterroza <wmonterroza@dartaero.com>; Shirley Hay <shay@dartaero.com>; Marie Lajeunesse <mlajeunesse<lmorris@dartaero.com>; Patrick Duval <pduval@dartaero.com>
Subject: Re: ECN 16-616, PHI skidtubes

Kim,

We have (4) work-orders for D206-642-541PHI skidtubes. The skidtubes are almost complete: they are painted black and the dwg attached is D3274 Rev. Prelim G.

Regarding ECN 16-616 that you are preparing. The released dwg & DSI should be attached to these work orders. The ECN co

However, the part numbers for these (4) work orders will have to be changed (per the new DSI 9749) to D206-642-561PHI.

Chris

Qty -041	Qty -043	Qty -045	Part Number	Description
X			D3274-041	SKIDTUBE ASSEMBLY
	X		D3274-043	SKIDTUBE ASSEMBLY
		X	D3274-045	SKIDTUBE ASSEMBLY (FOR PHI)
1	1	1	D2600-1-240	EXTRUSION
1	1	1	D2646	AFT CAP
12	12	12	D2649	CROSS BOLT SPACER
12	37	12	D3275-1	CROSS BOLT SPACER
1	1	1	D3282-041	FLOAT WEB
1	1	1	D3285-1	CAP
1	1	1	D3413-1	RING
1	1	1	D3415-041	NUT PLATE
9	9		D3537-1	WEARPAD
		1	D3537-11	WEARPAD
1	1		D3537-3	WEARPAD
		9	D3537-9	WEARPAD
2	2	2	D3672-1	WASHER
1	1		D4956-15	WEARSHOE
1	1		D4956-23	WEARSHOE
1	1		D4956-35	WEARSHOE
1	1		D4956-39	WEARSHOE
78	78	40	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
80	80	42	AN3C4A	BOLT
1	1		AN4C5A	BOLT
1	1	1	NAS1149C0463R	WASHER (AN960C416)
80	80	42	NAS1149C0332R	WASHER (AN960C10L)
2	2	2	CCR264SS3-3	RIVET
2	2	2	CR3212-4-03	RIVET
		1	MS27039D4-06	SCREW

GENERAL NOTES:

1. MATERIAL: N/A
2. FINISH:

ON -041/-043: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSTALLING D3282-041 WEB PRIME (REF. 4.2.1.3.3) OUTSIDE ONLY AND PAINT WHITE PER DART QSI 005 4.2 BLACK ANTI-SKID PAINT AS INDICATED TO 0.5" ABOVE LOCATION RIDGE PER DART QSI 005 4.4

ON -045: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSTALLING D3282-041 WEB PRIME (REF. 4.2.1.3.3) INSIDE AND OUTSIDE PER QSI 005 4.2.1 PAINT BLACK PER QSI 005 4.2.2 USING CA8213/F37038 CAMOFLAGE BLACK PER MIL-PRF-05285E TYPE I CLASS H. BLACK ANTI-SKID PAINT AS INDICATED TO 0.5" ABOVE LOCATION RIDGE PER DART QSI 005 4.4

3. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

4. UNITS: INCHES UNLESS OTHERWISE NOTED

5. BREAK SHARP EDGES 0.005 TO 0.010 MAX

6. IDENTIFICATION: N/A

7. WEIGHT: FOR -041/-043 = 37.5 LBS
FOR -045 = 33.4 LBS

8. WELDING TO BE DONE PER DART QSI 004.

9. ALL HOLES DRILLED ON CENTERLINES.

10. DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 7 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020" DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.

11. BOND D3282-041 FLOAT WEB INTO D3274-1/3 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.

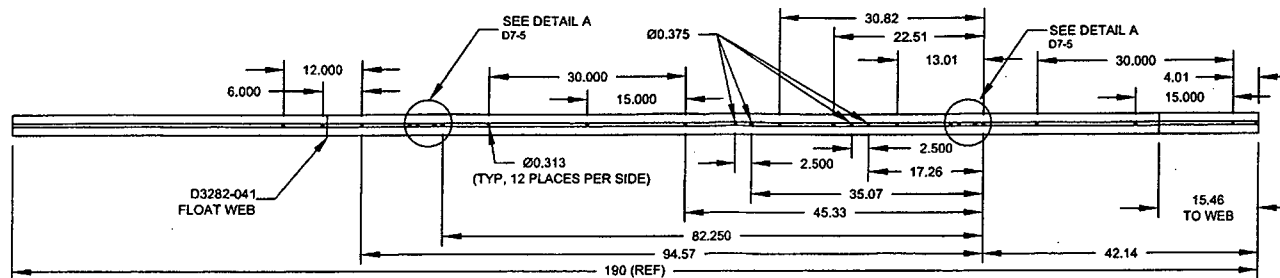
12. DRILL Ø0.297 HOLES FOR ALS7-1032-130 INSERTS USING DT3274-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX-241/291. ON -045, DO NOT DRILL HOLES OR INSTALL INSERTS FOR LONG WEARPLATES

13. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS GREASE WITH WASH 'N WIPE DEGREASER.

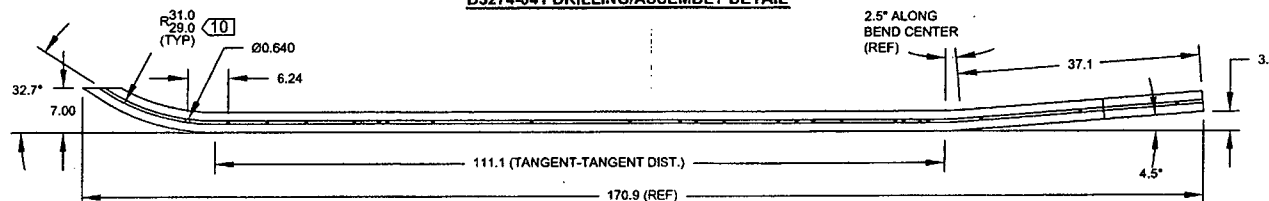
14. ON -045, APPLY COAT OF ROCKGUARD TO SKIDTUBE WHERE WEARPADS ARE INSTALLED.

G	ADD -045 CONFIGURATION (FOR PHI) ZN A5-4, A5-6 REVISE NOTE 2, 7 & 12, ADD NOTE 14 (ZN A8-1)	DS	16.04.25
F	REVISE NOTE 2: ADD ANTI-SKID PAINT, REMOVE GASKETS PER IIN-D206-642 REV Q	DB	14.04.15
E	REVISE NOTE 2: FINISH NOW PRIME/PAINT WAS POWDERCOAT, REF. PAR13-256	DW	13.05.17
D	NEW INSERTS, SS WEARSHOE + GASKET	CP	06.12.19
C	ADD -043; NEW INSERTS	CP	05.03.16
B	MOVE SADDLE HOLE: 42.14 WAS 42.76	CP	04.08.09
A	NEW ISSUE	CP	04.03.15
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE USA, INC EUGENE, OR	
DRAWN	RF		
CHECKED	AK	DRAWING NO.	REV. G
MFG. APPR.	JLM	D3274	SHEET 1 OF 6
APPROVED	DS	TITLE	SCALE
DE APPR.	RF	SKIDTUBE ASSEMBLY	NTS
DATE	16.04.25	COPYRIGHT © 2004 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

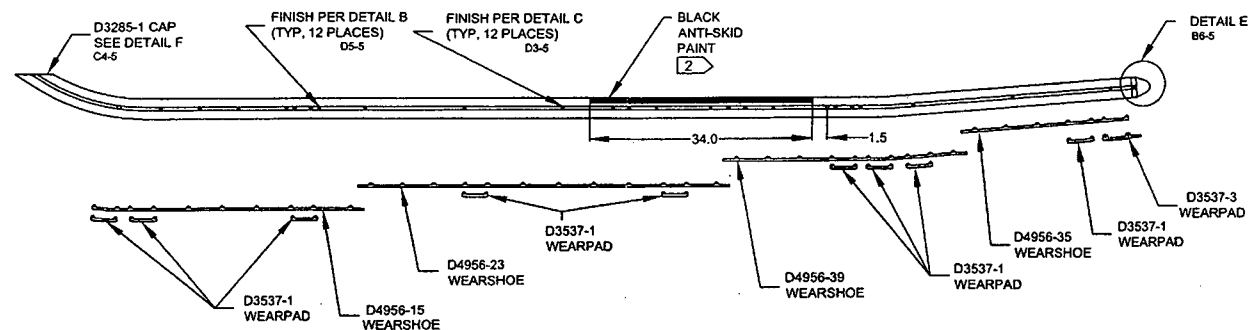
RELEASED
2016-07-26
ECN 16-616



D3274-041 DRILLING/ASSEMBLY DETAIL



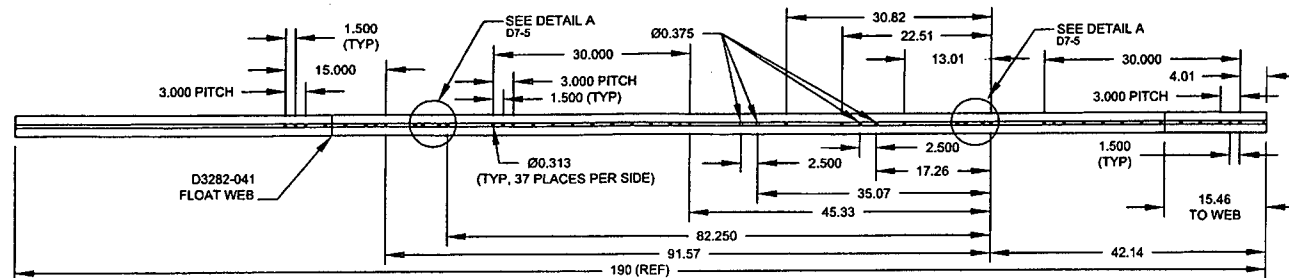
D3274-041 BEND/DRILLING DETAIL



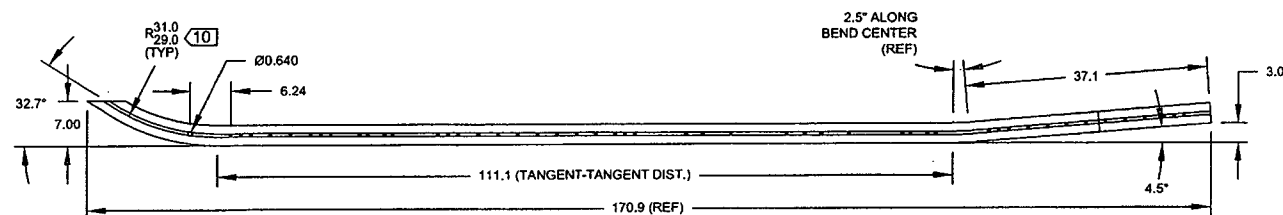
**D3274-041 SKIDTUBE ASSEMBLY
(SEE DETAIL D FOR WEARSHOE INSTALLATION)**

RELEASED
2016-07-26

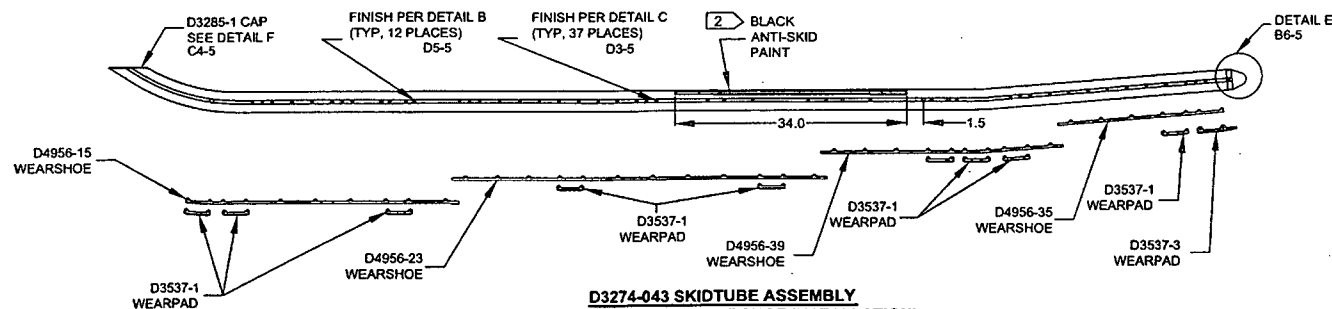
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DRAWN	RF	EUGENE, OR	
CHECKED	AK	DRAWING NO.	REV. G
MFG. APPR.	JLM	D3274	SHEET 2 OF 6
APPROVED	DS	TITLE	SCALE
DE APPR.	#	SKIDTUBE ASSEMBLY	NTS
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D3274-043 DRILLING/ASSEMBLY DETAIL



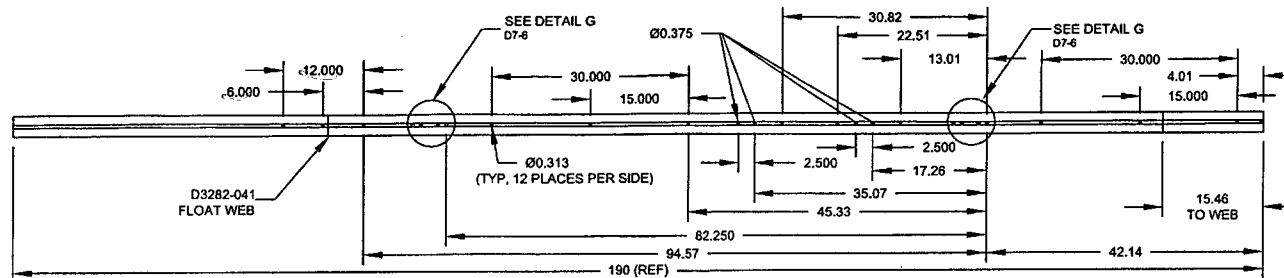
D3274-043 BEND/DRILLING DETAIL



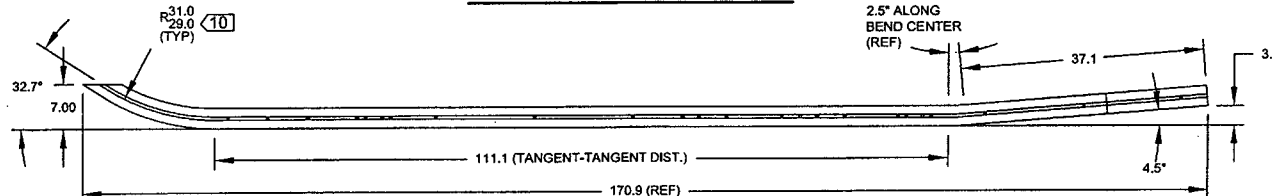
**D3274-043 SKIDTUBE ASSEMBLY
(SEE DETAIL D FOR WEARSHOE INSTALLATION)**

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2016-07-26

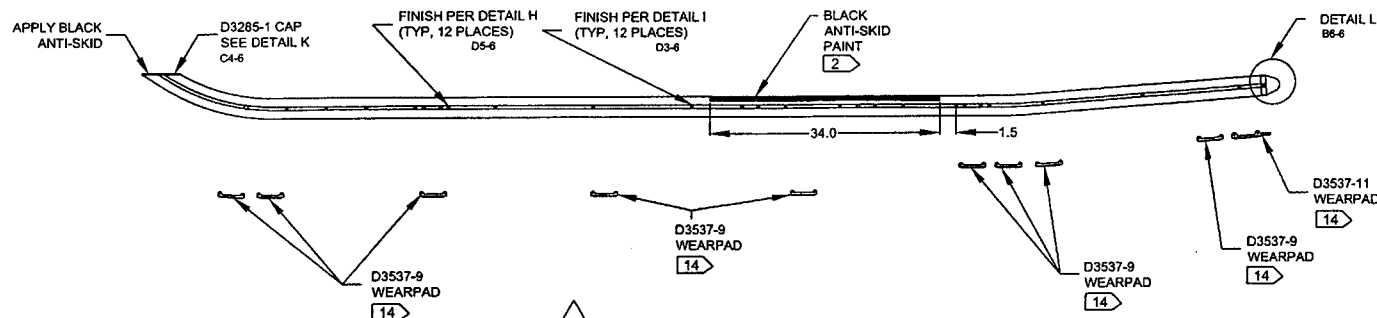
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DRAWN	RF	EUGENE, OR	
CHECKED	AK	DRAWING NO.	REV. G
MFG. APPR.	JLM	D3274	SHEET 3 OF 6
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DE APPR.	PL	SKIDTUBE ASSEMBLY	NTS
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D3274-045 DRILLING/ASSEMBLY DETAIL



D3274-045 BEND/DRILLING DETAIL

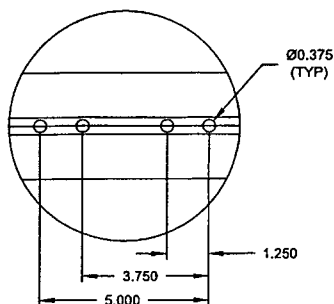


D3274-045 SKIDTUBE ASSEMBLY
(SEE DETAIL J FOR WEARSHOE INSTALLATION)

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2016-07-26

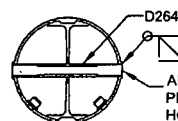
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CHECKED	AK	DRAWING NO.	REV. G
MFG. APPR.	JLM	D3274	SHEET 4 OF 6
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DE APPR.	DS	SKIDTUBE ASSEMBLY	NTS
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DETAIL A: DRILL DETAIL
D6-2, D3-2, D5-3, D3-3



DETAIL B
B6-2, B5-3

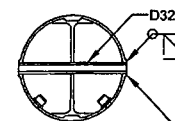
FOR Ø0.375 HOLES ONLY



- AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.375
HOLES ONLY:
1. CHAMFER HOLE 0.030x45°
 2. INSERT D2649 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. C'BORE TO Ø0.313x0.75 DEEP

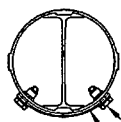
DETAIL C
B5-2, B4-3

FOR Ø0.313 HOLES ONLY



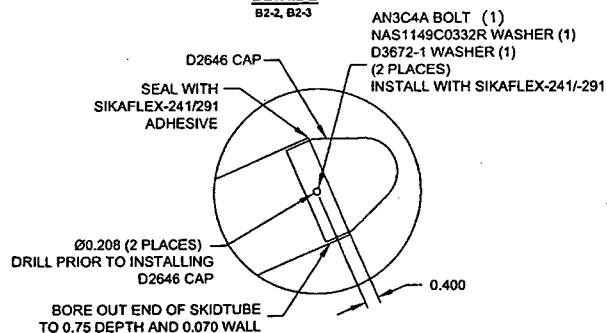
CHAMFER 0.030x45°
(TYP)

DETAIL D
A4-2, A4-3

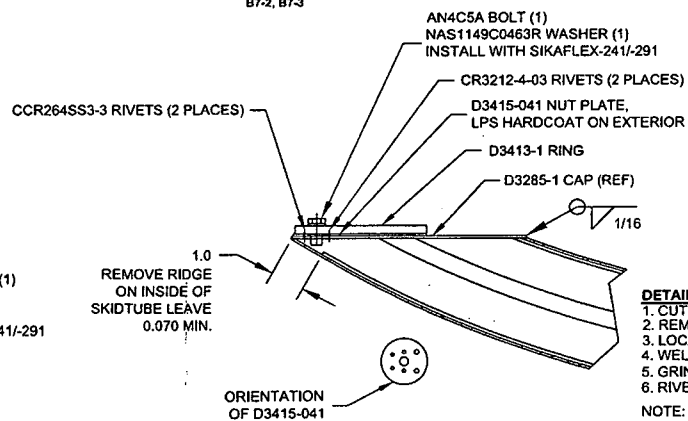


- ALS7-1032-130 INSERT (1)
AN3C4A BOLT (1)
NAS1149C0332R WASHER (1)
(78 PLACES)
WEARSHOE/WEARPAD (REF)

DETAIL E
B2-2, B2-3



DETAIL F: END FINISHING DETAIL
B7-2, B7-3



DETAIL F NOTES

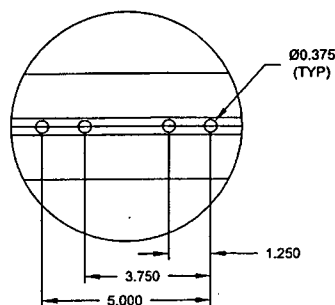
1. CUT TUBE LEVEL
 2. REMOVE RIDGE ON FWD SIDE
 3. LOCATE D3285-1 (TRIM AS NECESSARY)
 4. WELD D3285-1 IN PLACE PER DART QSI 004
 5. GRIND FLUSH
 6. RIVET D3415-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D3415-041
PRIOR TO FINISH

-041/-043 DETAILS

RELEASED
2016-07-26

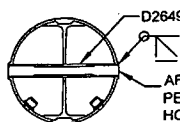
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CHECKED	AK	DRAWING NO.	REV. G
MFG. APPR.	JLM	D3274	SHEET 5 OF 6
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DETAIL G: DRILL DETAIL
D6-4, D3-4



DETAIL H
B6-4

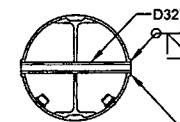
FOR Ø0.375 HOLES ONLY



AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.375
HOLES ONLY:
1. CHAMFER HOLE 0.030x45°
2. INSERT D2649 SPACER
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE TO Ø0.313x0.75 DEEP

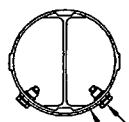
DETAIL I
B5-4

FOR Ø0.313 HOLES ONLY



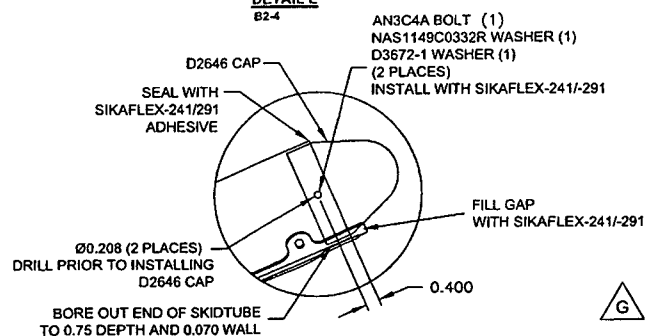
CHAMFER 0.030x45°
(TYP)

DETAIL J
A4-4

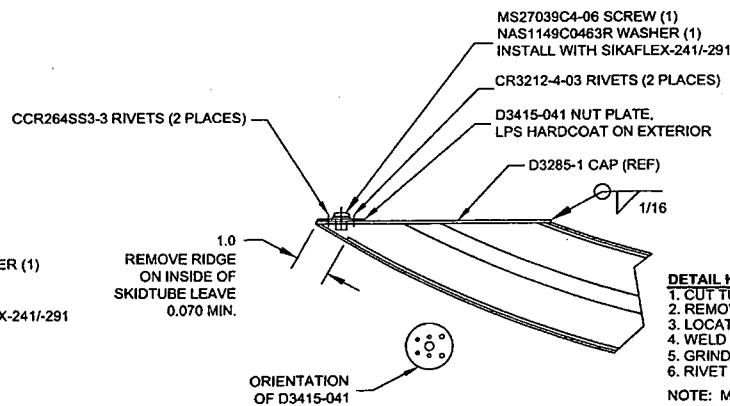


ALS7-1032-130 INSERT (1)
AN3C4A BOLT (1)
NAS1149C0332R WASHER (1)
(40 PLACES)
WEARPAD (REF)

DETAIL L
B2-4



DETAIL K: END FINISHING DETAIL
B7-4



DETAIL K NOTES

1. CUT TUBE LEVEL
 2. REMOVE RIDGE ON FWD SIDE
 3. LOCATE D3285-1 (TRIM AS NECESSARY)
 4. WELD D3285-1 IN PLACE PER DART QSI 004
 5. GRIND FLUSH
 6. RIVET D3415-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D3415-041
PRIOR TO FINISH



-045 DETAILS

RELEASED
2016-07-26

DESIGN	CP	DART AEROSPACE USA, INC	
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CHECKED	AK	DRAWING NO.	REV. G
MFG. APPR.	JLM	D3274	SHEET 6 OF 6
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